Work Order ID 59218

Friday, May 28, 2010 9:24:25 AM

Item ID: D2565-101
Revision ID:
Item Name: Strut
Start Date: 5/27/2010 **Start Qty:** 8.00
Required Date: 6/4/2010 **Req'd Qty:** 8.00
Reference:

Accept

Setup Start
Stop

Cust Item ID:
Customer:

Approvals: **Process Plan:** M **Date:** 10-5-28 **Tooling:** _____ **Date:** _____
QC: _____ **Date:** _____ **SPC (Y/N):** _____ **Date:** _____

Run Start
Stop

Draw Nbr	Revision Nbr
D2565	Rev E

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
100 Brake NC Brake NC	NC BRAKE **Memo** Punch as per Dwg D2565 using DT 8313	0.00 0.00 SB 10/06/02				8			
110 Small Fab Small Fab	Small Fab **Memo** Drill hole open to .316 Ø as per Dwg D2565 (one end only) ☐Deburr and polish	0.00 0.00				8 10/06/03			
120 QC Quality Control	QC5- Inspect part completeness to step on W/O **Memo**	0.00 S 10/06/03 0.00				X8			

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W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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130 Powdercoat	White Gloss(Ref:4.3.5.2) per QSI005 4.3-Steel AR114207	0.00							
Powder Coating	Memo	0.00				8	0		
	START TIME: 11:30AM ☐OVEN TEMPERATURE: 12:00pm ☐FINISH TIME: 400°F								
140 QC	QC3- Inspect Part Finish	0.00							
Quality Control	Memo	0.00				8	BR 10-6-7		
150 Packaging	Identify as per dwg & Stock Location: 210	0.00							
Packaging	Memo	0.00				8			

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QC: _____ **Date:** _____ **SPC (Y/N):** _____ **Date:** _____

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
160	QC21- Final Inspection - Work Order Release	0.00							
QC Quality Control	**Memo**	0.00							

10/06/08

MF

10-6-8

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Picklist Print

Friday, May 28, 2010 9:24:29 AM

Work Order ID: 59218

Parent Item: D2565-101

Parent Item Name: Strut

Comments: IPP: F□02.04.16□Added dwg Rev.C1□NG□

Start Date: 5/27/2010 **Required Date:** 6/4/2010

Start Qty: 8.00 **Required Qty:** 8.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M304TR0.750W.049 304 RD Tube .750 x .049W		Purchased	No			100	f	108.1489	1.71	14.4			

Location		Loc Qty	Loc Code
MAT		80.2854	
	108498	0	
	114482	80.2854	
MAT017		27.8635	
	109314	9.33	
	110113	5.29	
	112800	13.2435	

16

SB colac loc

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Part No: _____ **PAR #:** _____ **Fault Category:** _____ **NCR:** Yes No **DQA:** _____ **Date:** _____

Resolution: _____ **Disposition:** _____ **QA: N/C Closed:** _____ **Date:** _____

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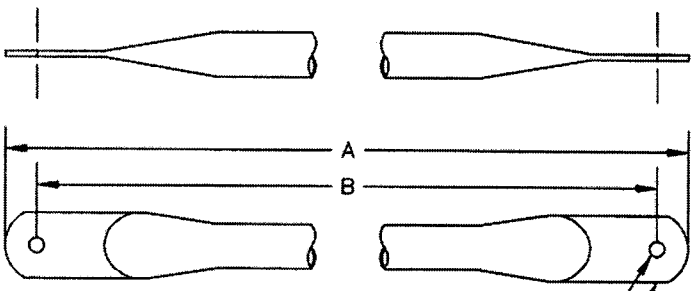
DESIGN	DRAWN BY	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED	APPROVED	DRAWING NO. D2565	REV. E SHEET 1 OF 1
DATE 04.05.05		TITLE STRUT	SCALE 1:3

A	96.05.03	NEW ISSUE
B	97.03.15	CORRECT D2565-111 DIM. A
C	98.10.05	UPDATED MATERIAL NOTE (TSR A603)
D	02.06.05	ADD -3XX PARTS; ADD FINISH
E	04.05.05	ADD D2565-401-411; RMV ANGLE D

RELEASED
04 05 05



DIA 0.257 TO BE PUNCHED
"C" DIA TO BE OPENED MANUALLY

PUNCH ENDS PER SPEC CONTROL DRAWING D2638

PART #	A	B	DIA C
D2565-101	20.52	19.72	0.316
D2565-103	18.21	17.41	0.316
D2565-105	20.19	19.39	0.316
D2565-107	13.43	12.63	–
D2565-109	12.31	11.51	–
D2565-111	13.65	12.85	–
D2565-201	22.79	22.00	0.316
D2565-203	20.75	19.95	0.316
D2565-205	21.22	20.42	0.316
D2565-207	16.07	15.27	–
D2565-209	15.16	14.36	–
D2565-211	14.14	13.34	–
D2565-301	27.03	26.23	0.316
D2565-303	25.34	24.54	0.316
D2565-305	23.73	22.93	0.316
D2565-307	20.86	20.06	–
D2565-309	20.17	19.37	–
D2565-311	16.30	15.50	–
D2565-401	18.29	17.49	0.316
D2565-403	15.64	14.84	0.316
D2565-405	19.45	18.65	0.316
D2565-407	10.79	9.99	–
D2565-409	9.34	8.54	–
D2565-411	13.81	13.01	–

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 59218
10-5-28

GENERAL NOTES

1) MATERIAL: AISI 304/316/318 SS 0.750 OD X 0.049 WALL
(REF DART SPEC. M304TR0.750W0.049)
ENSURE SEAMLESS TUBE IS USED
2) FINISH: POWDER COAT WHITE (4.3.5.2) PER DART QSI 005 4.3
3) TOLERANCES PER DART QSI 018 UNLESS OTHERWISE NOTED
4) ALL DIMENSIONS ARE IN INCHES

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